

Date: Wednesday, 1/18/2006 4:04:59 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER
Job Number	: 25556F		
Estimate Number	: 10287		
P.O. Number	: N/A	Part Number	: D32021
This Issue	: 1/18/2006 S.O. No. : N/A	Drawing Number	: D3202 REV B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 25442F	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 2/15/2006
Checked & Approved By	: <u>SEE ABOVE USE &amp; DATE</u>	Qty:	10 U: Each
Comment	: Est Rev:B No Longer Made In House 05-11-06 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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## Comment: PURCHASING

Issue P/O: 00000450 06/01/26  
 E-mail or Ship DXF file to vendor  
 Laser cut flat pattern as per Dwg  
 Possible supplier: Ind. Laser  
 Material release note is required.

(10)

2.0	D32021F	Cover
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10 0000 Each(s)  
 Cover

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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## Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage  
 Ensure material certification is attached

C 206/03/10 9/10

4.0	QC6	DIMENSIONAL CHECK
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## Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

SAD 06.03.26

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: DD Date: 06/04/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:04:59 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 25556F

Part Number: D32021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD

06:04:02

(19)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DL 06/04/02

(18)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 6/4/03

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 86 st

DL 6/4/03

(10)

Job Completion



Inspection Level 2

W Dondy-04

06/04/04

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

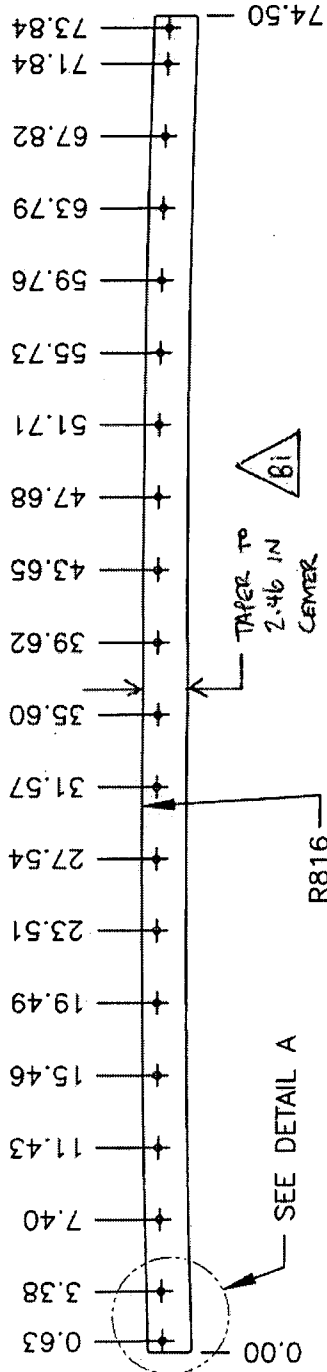
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



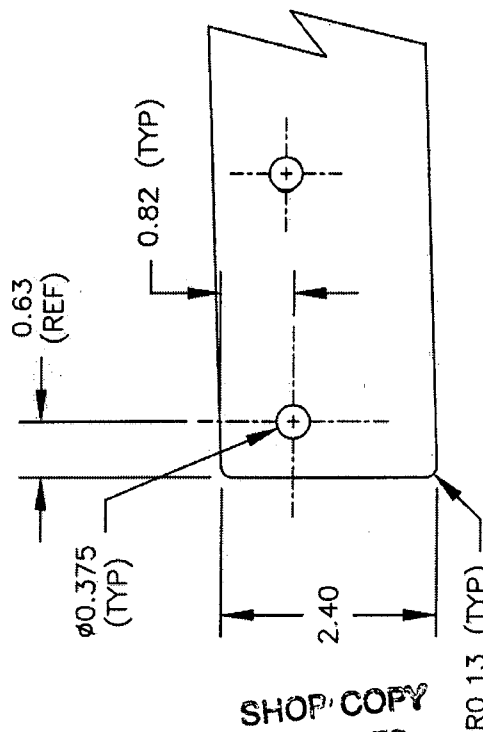
DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3202	REV. B SHEET 1 OF 1
DATE 03.10.16		TITLE COVER	SCALE 1:10
A	01.01.01	NEW ISSUE	
B	03.10.16	REDESIGN; PART NOW CURVED	
BI	<i>CP</i> 04.05.14	CLARIFY MID-SPAN DIMENSION	



RELEASED

03.11.07

DETAIL A  
SCALE 1:2



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 25566F

D3202-1 COVER

- 1) MATERIAL: 5052-H32/H34 SHEET (QQ-A-250/8) 0.032 THICK (REF DART SPEC. M5052H32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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## Packing List Shipping Order

MO #

12311 HORSESHOE WAY  
12311 HORSESHOE WAY  
Phone: (604) 272-2422

RICHMOND BC V7A 4X6  
RICHMOND BC V7A 4X6

Page 1 of 1 02/21/06 18:37 CST  
SO AP

Order Number

90-373971

Purchase Order

110871

SOLD TO:

INDUSTRIAL LASER CUTTING LTD  
#7 - 7504 VANTAGE PLACE  
PHONE: 604 946 4152

SHIP TO:

Phone: (604) 946-4152  
INDUSTRIAL LASER CUTTING LTD  
C/O CIKING PROFILES INC 604 821 0773  
14471 KNOX WAY  
RICHMOND BC V5V 2Z1

Total Packages: 1

Ship Via	Freight	Customer #	Sales	Tax Status	Contact	Certs	Due Date
STRAIT EXPRESS	FOB Warehouse Collect	443322	6 CD	TAXABLE		1	02/22/2006
Bill of Lading:	Pro Bill:	Ship Approval:	Ship Date:	Order Date:			
				02/21/2006			

Line No.	Item	Description	Qty Shipped	B/O Quantity
1	5458-2572	AL SHT TL QQA250/8 5052H32 .032 X 48 X 96		
Qty Comm: 3 SHTS	Order Qty: 3	UEA	Pcs: 3	3.00 UEA
( 1 -SKID 83 4X8 )				
	Cntrl: 90277428 R: 467071	T: 467071	3 pcs Loc PEND	Wt: 43
	PLS SHIP STRAIT EXPRESS COLLECT			
*** FILLED BY INITIALS: PD				

P.O. 450

Customer/Driver Instructions:  
WILL TEST REPORTS REQUIRED ALL SHIPMENTS

Received by: \_\_\_\_\_ Date: \_\_\_\_\_  
Acceptance of goods constitutes acceptance of our Terms and Conditions, available on our website at [www.integrismetals.com](http://www.integrismetals.com)  
(or from your sales representative, or by calling (800) 328-7800).

PACKING LIST

Alloys of Aluminum, Copper, Steel Caution:  
Processing of this material may present a physical and or health hazard. See material safety data sheets for further information

## MATERIAL TEST REPORT

From: PECHINEY ROLLED PRODUCTS  
CENTURY ROAD  
P.O. BOX 68  
RAVENSWOOD, WV, 26164

Page : 1  
Heat/Lot : 467071  
TIN : 467071

Sold To: INTEGRIS METALS, LTD.  
12311 HORSESHOE WAY  
RICHMOND, BC V7A 4X6

Ship To: 2306 "B" STREET NW  
AUBURN WA  
98002

### Vendor Information

Chal. PO #: 20991

Cust. PO DT: 01/08/06

### Specifications

RAVENSWOOD DISTRIBUTOR  
SPEC COTI, NON HT MILL  
AMS-QQ A 250/8  
ALSO CONFORMS TO ASTM B209-04  
Buyer Part: 54582309  
5052 H32 .032 IN 48 IN

### Mechanical Tests

	Min	UOM	L	O	Max	UOM	L	O
Number of Tests: 2								
Ult Tensile Str, longitudinal	34.6	KSI	LONG		35.4	KSI	LONG	
Yield Strength	28.3	KSI	LONG		29.6	KSI	LONG	
Elongation, Longitudinal	9	PCT	LONG		9.5	PCT	LONG	

### Chemical Composition

SI Silicon Pct	.130	FE Iron-Pct	.240
CU Copper-Pct	.040	MN Manganese-Pct	.030
MG Magnesium Pct	2.340	CR Chromium-Pct	.190
ZN Zinc-Pct	.020	OF Others Each Max-Pct	.050
OT Others Tot Max-Pct	.150	Al Remainder-Pct	

Comments

## MATERIAL TEST REPORT

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CENTURY ROAD  
P.O. BOX 68  
RAVENSWOOD, WV, 26164

Page : 2  
Heat/Lot : 467071  
TIN : 467071

### CERTIFICATION

Pechiney Rolled Products / Ravenwood Distribution

certifies that metal shipped under this order has been inspected and tested and found in conformance with the requirements of the applicable specifications as indicated herein. any warranty is limited to that shown on PRP(s) standard General Terms and Conditions of Sales. Test reports are on file, subject to examination

PECHINEY ROLLED PRODUCTS

RAVENSWOOD OPERATIONS - RAVNSWOOD, WV. 26164

QA by MARK PARSONS 10/27/2005

*Miscellaneous Data*

Control #: 90277428 Date: 02/21/06

S.O. Number: 590 373971 1

AL SHI TL QQA250X8 5052H32

Customer P.O.: 110H/1

.032 X 48 X 96

06.03.15

The Chemical Analysis and Mechanical Test data was received via EDI from the above mentioned vendor.

INTEGRIS METALS, LTD.